

5/23

DART AEROSPACE LTD	Work Order:	23140
Description: Wearshoe	Part Number:	D2656-13
Drawing: D2656 Rev. C	Qty:	50
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	DF	05.04.29	50
2	PG	Issue P/O: 7004903 Email or ship DXF file to vendor Laser Cut per Dwg D2656 flat pattern D2656-13 Material release note required	LL	05.05.03	50
3	RG	Receive and Inspect for transit damage Ensure the material note is attached	CL	05/05/16	50
4	QC6	Inspect dimensions per template D2656-13T1 DRAWING	ML	05/05/25	50
5	GB	Deburr if necessary	N/A, ML	05/05/25	50
6	GB	Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326	FF	05.08.15	50
7	GB	Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13	FF	05.08.17	50
8	QC5	Inspect work to Step 7	J	05.08.18	50
9	FP	Powder Coat Grey (RAL-7012) (Ref. 4.3.5.5) per QSI 005 4.3	FC	05 08 22	50
10	QC3	Inspect Powder Coat	ML	05 08 23	50
11	FP	Identify and Stock	FC	05 08 24	50
12	AC	Cost / part: 14.02	54C	05.08.25	50
13	DC	Close W/O 13.58 Inspect Level 21	DF	05/08/25	50

Rev	Date	Change	Revised By	Approved
B	99.03.16	Re-format	DM	
C	00.11.01	Removed P/O for Powder Coat – in house process	EC	
D	01.04.10	In house process	EC	
E	01.06.26	Added step 2 to 4, added inspection level 21	EC	
F	02.10.25	Re-format	KJ RF	


RELEASED
02/10/30 RF

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA:  Date: 05/08/25
QA: N/C Closed: _____ Date: _____

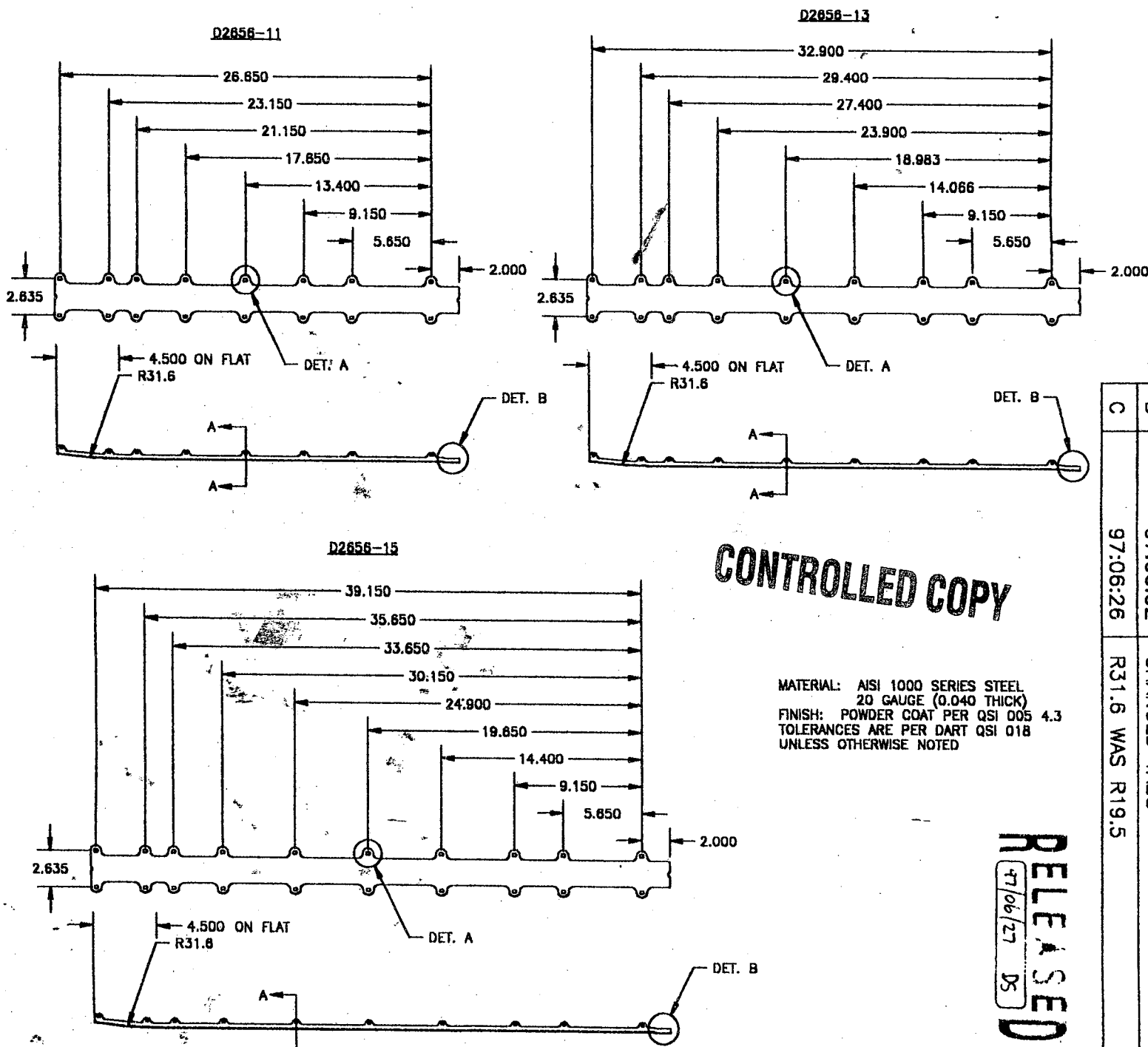
DART

DESIGN BY <i>MM</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC FAIRCHILD INTERNATIONAL AIRPORT, USA	REV. C
CHECKED <i>MM</i>	APPROVED <i>BD</i>	DRAWING NO. D2656	SHEET 1 OF 4
DATE 97:06:26	TITLE WEARSHOE	SCALE 1:10	
A	97:03:25	NEW ISSUE	
B	97:06:02	CHANGED TABS	
C	97:06:26	R31.6 WAS R19.5	

CONTROLLED COPY

MATERIAL: AISI 1000 SERIES STEEL
20 GAUGE (0.040 THICK)
FINISH: POWDER COAT PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
47/06/27 DS



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 29, 2005
11:31 am

Work Order No : 0023140
Project Name : D2656-13
Project For : WK523
Work Order Type : Main
Main WO Number :
House Part Number : D2656-13
Description : Wearplate
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 04-29-05
Est Finish Date : 06-05-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
	=====	=====	=====		
Burden :	0.00	0.00	0.00		
	=====	=====	=====		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



New Zealand Steel Limited
 Glenbrook, South Auckland
 Postal: Private Bag 92121, Auckland, New Zealand
 Telephones: (09) 3758 989 Auckland
 (09) 2568 009 Waikato
 Fax: (09) 3758 959 Telex 24938

TEST CERTIFICATE

Ref: 3561/12021

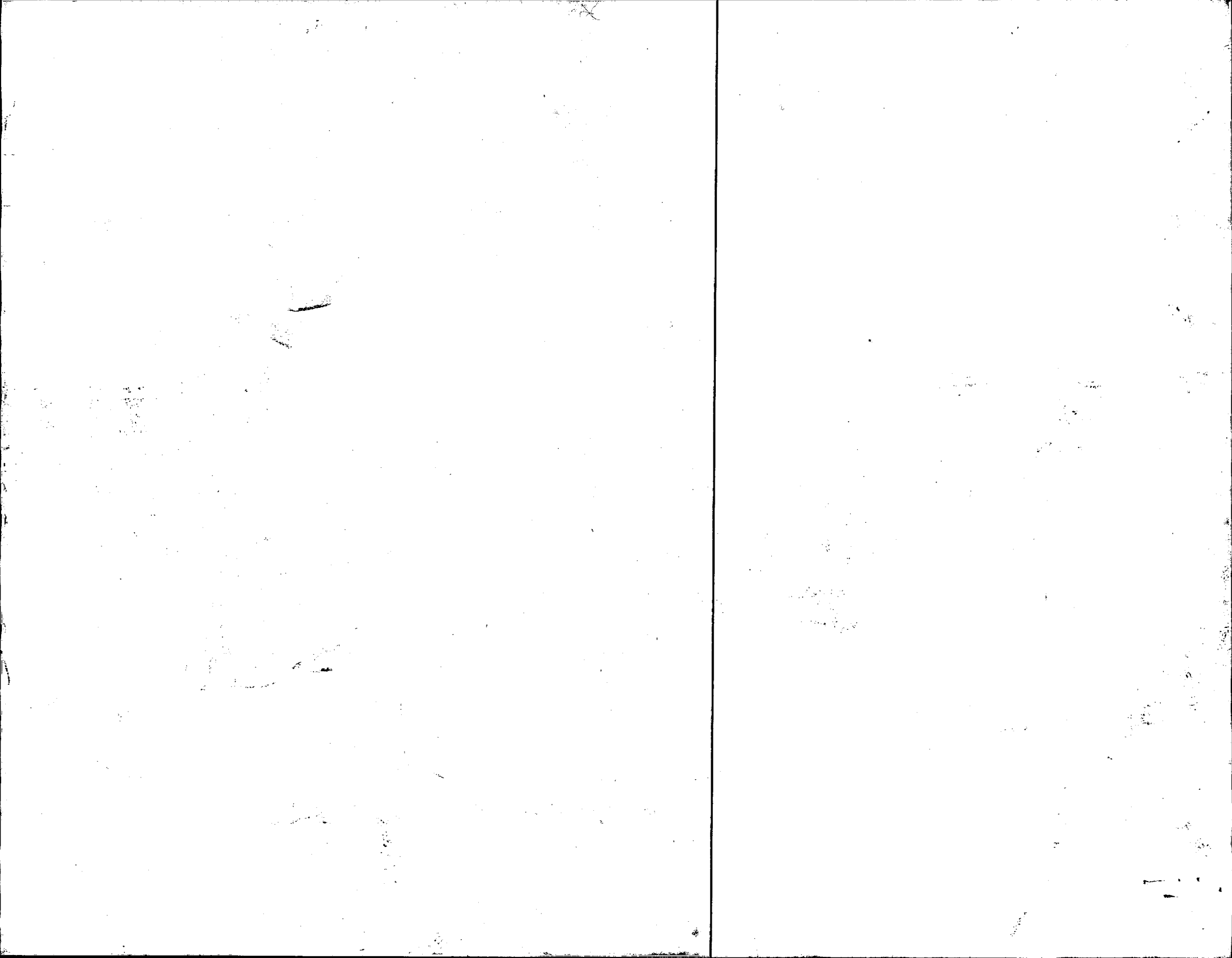
CUSTOMER	Wilkinson	P30430N1001	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC072790																			
CUSTOMER O/N	96-21N-141		PRODUCT	CRA WIDE COIL	PAGE	1 of 1																			
MILL O/N	375624		DIMENSIONS	0.033" x 48" x Coil	DATE	29 August 2003																			
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)									
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH	
		x100															x1000	x10000	x100	180°		GL =	HRB	()	(feet)
R9-413484-00	625796	5	TR	20	8	9	12	18	20	1	5	1	1												
R9-413485-00	625796	5	TR	20	8	9	12	18	20	1	5	1	1									44		2467	
R9-414003-00	625794	5	1	20	8	11	12	18	21	3	6	1	1									44		2589	
R9-414004-00	625794	5	1	20	8	11	12	18	21	3	6	1	1									49		2644	
																						49		2690	

20 GA MS

YIELD		GAUGE LENGTH (G L)			PLASTIC STRAIN RATIO (r)		IMPACT TEST		CARBON EQUIVALENT VALUE (CE)		
(A)=0.2% PROOF STRESS	(A)=200mm	(C)=80mm	(E)=2"	(A)=U	(C)=45	(A)=10mm x 10mm	(C)=5mm x 5mm	(A)=C+W/N/6	(C)=C+W/N/6+3/24		
(B)=LOWER YIELD STRESS	(B)=50mm	(D)=5.65 S ₀	(F)=8"	(B)=90	(D)=(r0+r90+2r45) / 4	(B)=7.5mm x 10mm	(E)=5mm x 10mm	(B)=C+W/N/6+(Cr+W+Mo)/5+(Cu+Ni)/15	(D)=		

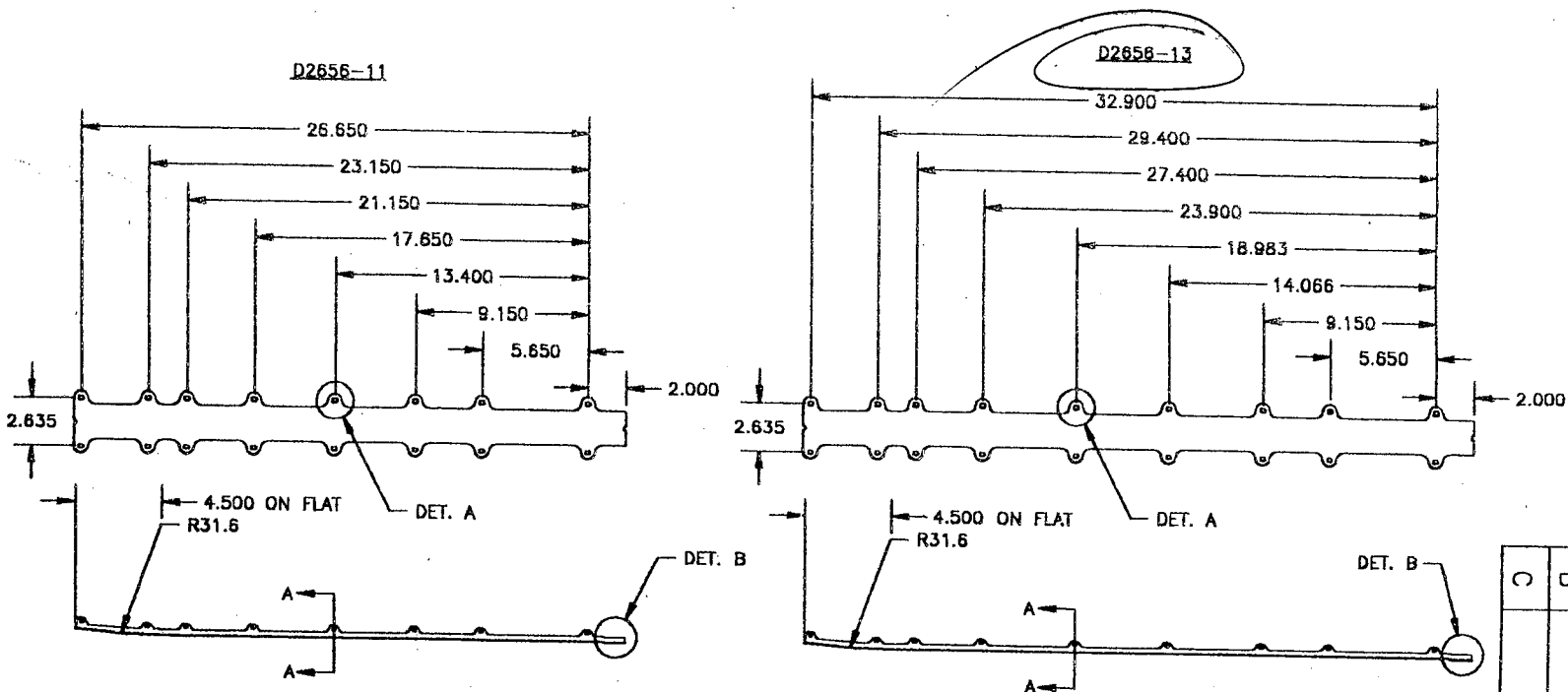
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
 WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Atish Misra*
 QC METALLURGIST





DESIGN	DRAWN BY	DART AEROSPACE USA, INC
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, USA
DATE	TITLE	REV. C
97:06:26	WEARSHOE	SHEET 1 OF 4
A	97:03:25	NEW ISSUE
B	97:06:02	CHANGED TABS
C	97:06:26	R31.6 WAS R19.5



CONTROLLED COPY

MATERIAL: AISI 1000 SERIES STEEL
20 GAUGE (0.040 THICK)
FINISH: POWDER COAT PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

REFERENCE ONLY

RELEASED
7/06/27 DS

D2656-15

